

# EUROPEAN PATENT OFFICE

## Patent Abstracts of Japan

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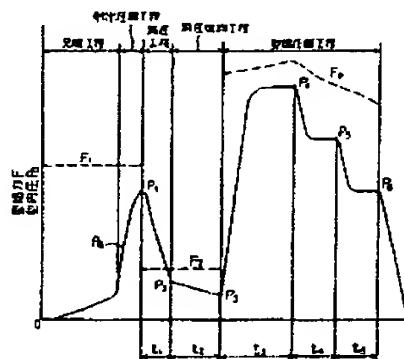
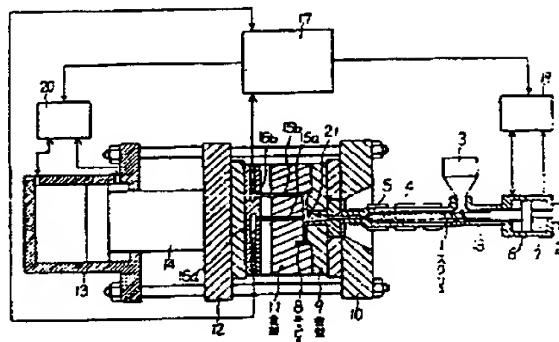
APPLICATION DATE : 17-07-85  
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INVENTOR : TSURUMAKI MASA;

INT.CL. : B29C 45/70 B29C 45/76

TITLE : INJECTION MOLDING PROCESS



**ABSTRACT :** PURPOSE: To make the photocharacteristic of a molded product to be excellent, removing its residual stress-fracture, warpage and deformation by a method in which the incline of the inner pressure of a mold in the flow direction of a molded product before the process of mold clamping/compressing, is omitted, and the mold clamping/compressing is further precisely multistage-controlled.

CONSTITUTION: To equalize the amount of injected resin of every shot when the inner pressure  $P_a$  of a mold (near a gate) obtained by a sensor 16a reaches injecting compressive pressure  $P_1$  (filling pressure in the mold plus compressive pressure) having been preliminarily set, a screw 1 is retreated and the inner pressure is reduced to  $P_2$  from  $P_1$ . After that, the inner pressure  $P_a$  of the mold is regulated to  $P_3$  by the fine advance and retreat of the screw correspondingly to the change of the inner pressure  $P_b$  (the end of resin blow) of the mold obtained by the sensor 16. Its regulation time is controlled with the fine regulation timer  $t_2$  for pressure reducing constant. Then, the process is advanced to the compression caused by mold clamping pressure, and the detected inner pressure  $P_a$  of the mold is compared with preliminarily set values  $P_4$ ,  $P_5$ ,  $P_6$ , thereby operating the control mechanism 20 for mold clamping, and controlling the mold clamping process by a closed loop.

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